

**AMENDMENTS TO THE CLAIMS**

The following listing of claims will replace all prior versions and listings of claims in the application.

**LISTING OF CLAIMS**

1 through 28. (Canceled)

29. (Previously Presented) A method of manufacturing a gear comprising:

providing a die assembly having an upper die, a lower die and a mandrel, one of the upper die and the lower die defining a plurality of gear teeth, the upper and lower dies forming a closed die that defines a die cavity, the mandrel having a plurality of splines formed thereon, the mandrel being received into the die cavity;

providing an insert portion formed of a solid substantially void-free metal, the insert portion having a hollow body and a flange, the hollow body having opposite axial end faces and an interior surface into which a plurality of mating splines are formed, the flange extending circumferentially about the hollow body between the opposite axial end faces of the hollow body;

positioning the insert portion onto the mandrel such that at least a portion of the mating splines of the insert portion matingly engage the splines formed on the mandrel;

positioning a preform portion within the die cavity such that the perform portion extends circumferentially about at least a portion of the insert portion, the perform portion being formed of a solid substantially void-free metal; and

pressing the preform portion between the upper and lower dies in a pressing direction to form a gear in single stroke such that a plurality of gear teeth are formed on the preform portion, the perform portion deforming in at least one axial direction, a radially inward direction

312 Entered 5.1 - 8/28/2006